

Work Order ID 73555

Friday, September 02, 2011 9:23:18 AM

Page 1

Item ID: D4006-041

Accept

Revision ID:

Item Name: Tank Top Support Assembly

Start Date: 9/2/2011 Start Qty: 4.00

Required Date: 9/13/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4006

A

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time:

Oven Temperature:

Finish Time:

8:10
320 OF
8:40

M 117338



Setup Start



Stop



Cust Item ID:

Customer:

ASAP

Run Start



Stop



9/11/09/21 (4)

(14)

4X of M-11/09/21

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H BK 11-9-21.

140

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Apply glue and install Foam as per dwg 3M 1300 countact cement
Batch: M11 7780
2- Install anchor nuts as per dwg

Ep 11/09/21 (4)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sul 9/21

(+4)

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Identify as per dwg & Stock Location: 107

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/22

11/9/22
ME
11-09-22

Picklist Print

Friday, September 02, 2011 9:23:15 AM

Page 1

Work Order ID: 73555

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly



Start Date: 9/2/2011

Required Date: 9/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JEM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4006-1



Angle

Manufactured

No

100

Each

12.0000

1

4

Location

Loc Qty

Loc Code

GA

12

70187

12

D4006-3



Channel

Manufactured

No

100

Each

5.0000

2

8

Location

Loc Qty

Loc Code

ST107

5

71403

5

D4006-5



Foam

Manufactured

No

140

Each

8.0000

1

4

Location

Loc Qty

Loc Code

ST107

8

63940

8

MS20426AD3-4



RIVET

Purchased

No

140

Each

5,028.000

4

16

Location

Loc Qty

Loc Code

ST316

5028

104374

1122

110398

3906

370187 (4x)

372752 (7x)

16

16

Picklist Print

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Page 2

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Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 9/2/2011

Required Date: 9/13/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-5

Purchased

No

100

Each

3,026.000

8

32



Rivet, Universal Head



EP 5/11/09/21

Location

Loc Qty

Loc Code

ST319

3026

116893

131

118405

2895

MS21059L4

Purchased

No

140

Each

67.0000

2

8



Nutplate



EP 5/11/09/21

Location

Loc Qty

Loc Code

ST301

67

117887

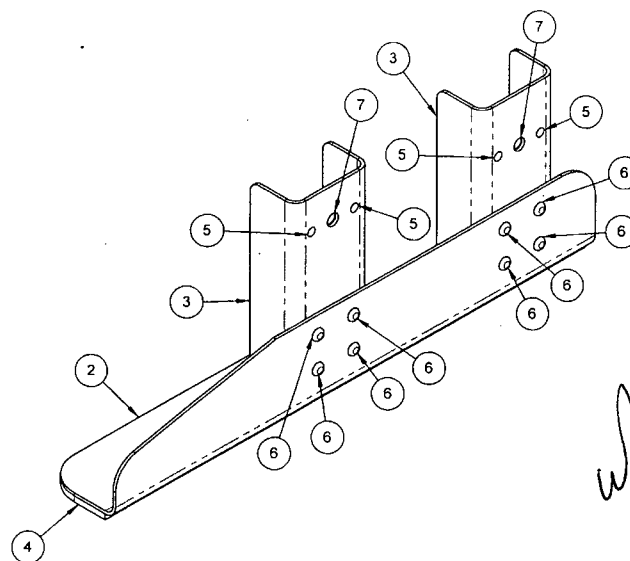
17

118612

50

8

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

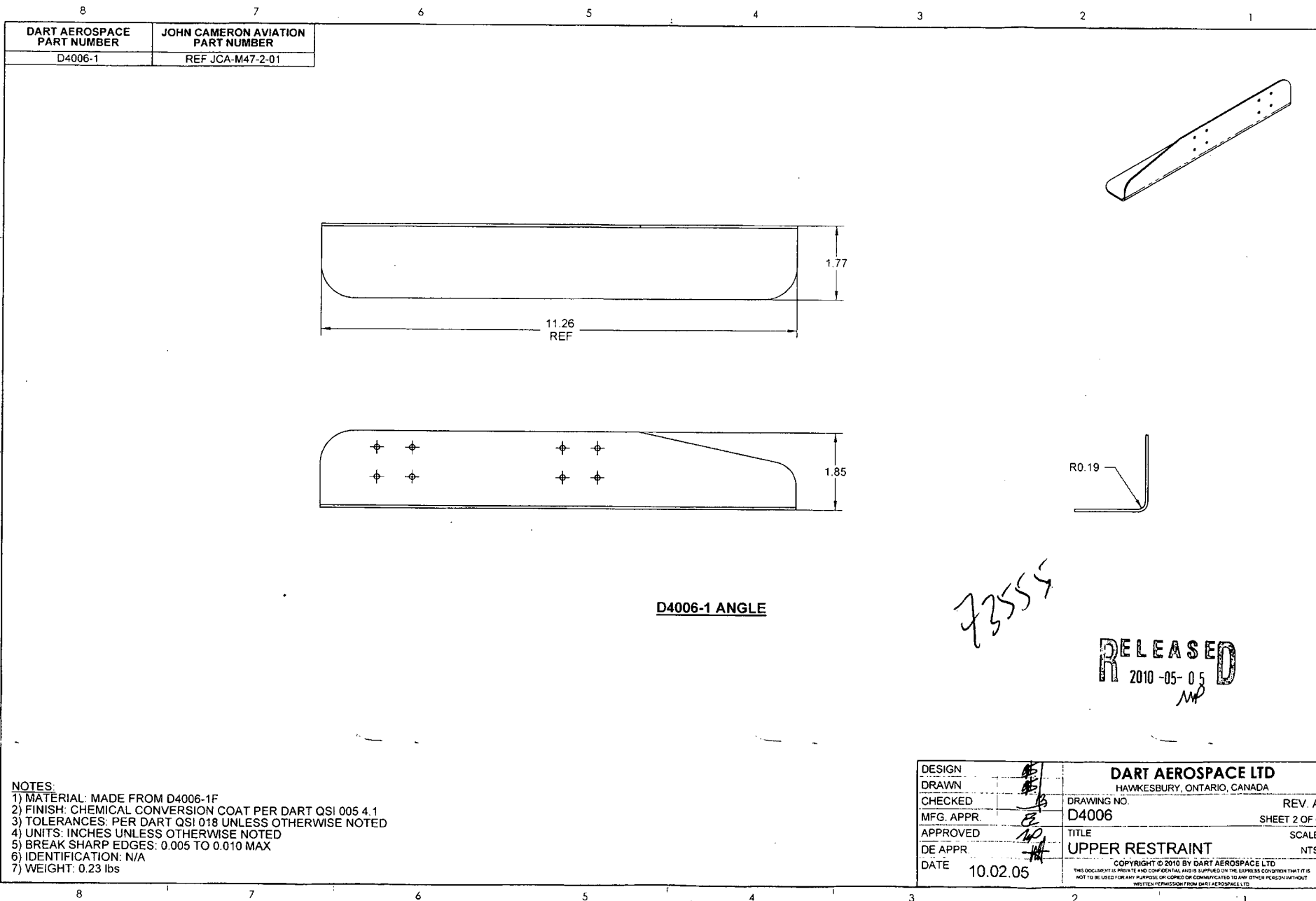
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DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	10.02.05				

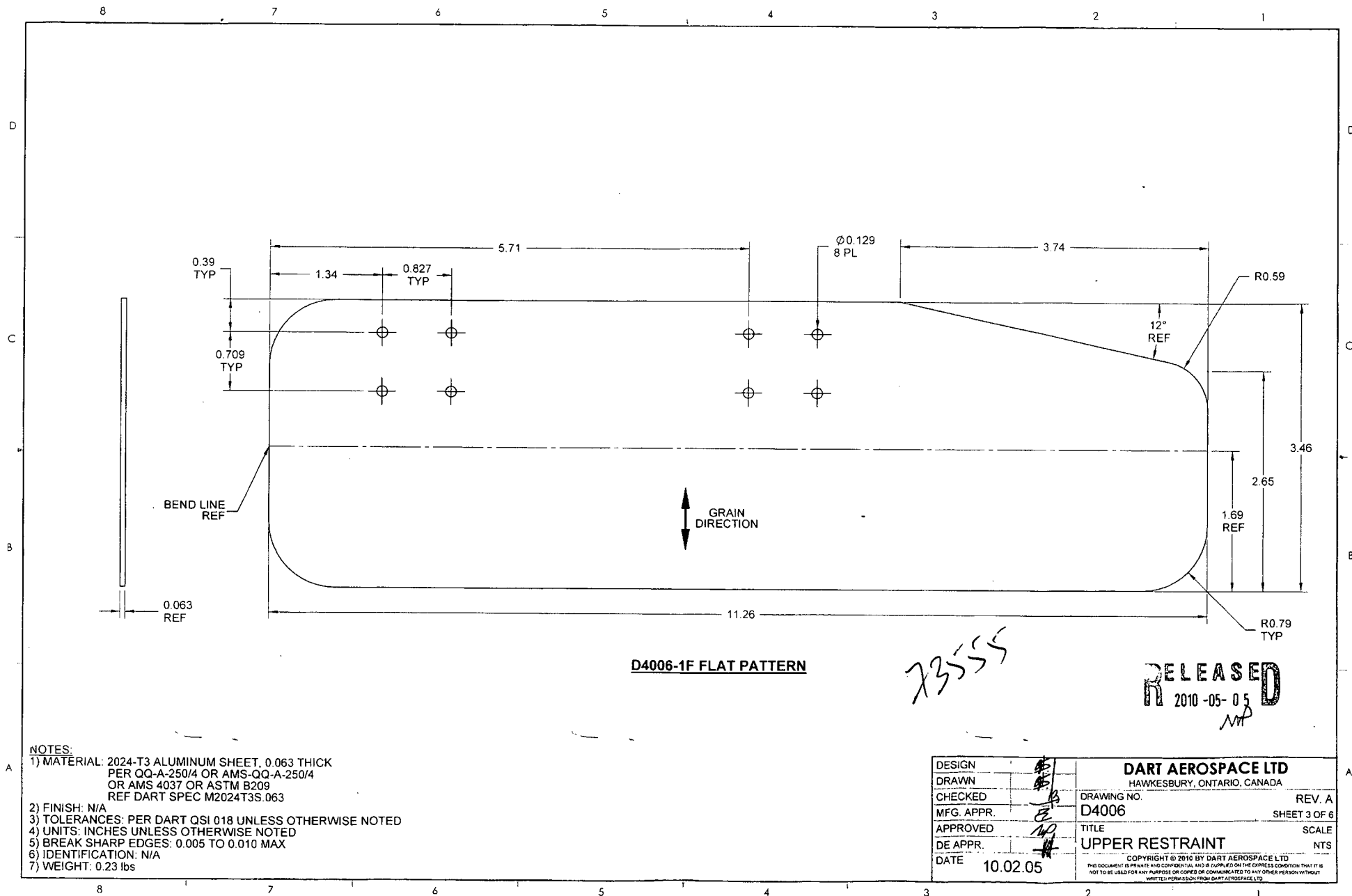
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4006	REV. A SHEET 1 OF 6
TITLE UPPER RESTRAINT	SCALE NTS

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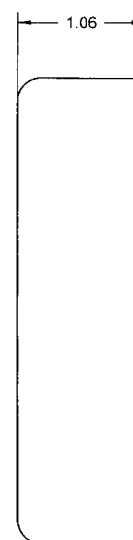
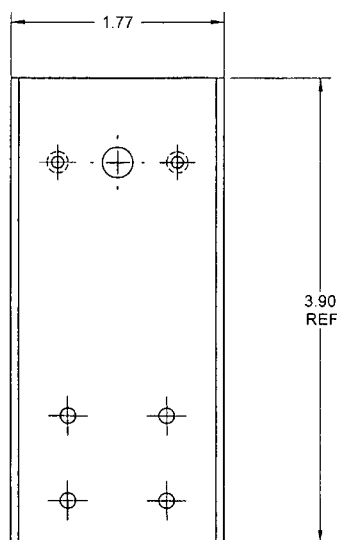
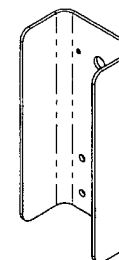
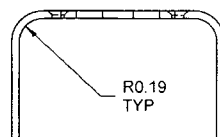




NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-3	REF JCA-M47-2-01



D4006-3 CHANNEL

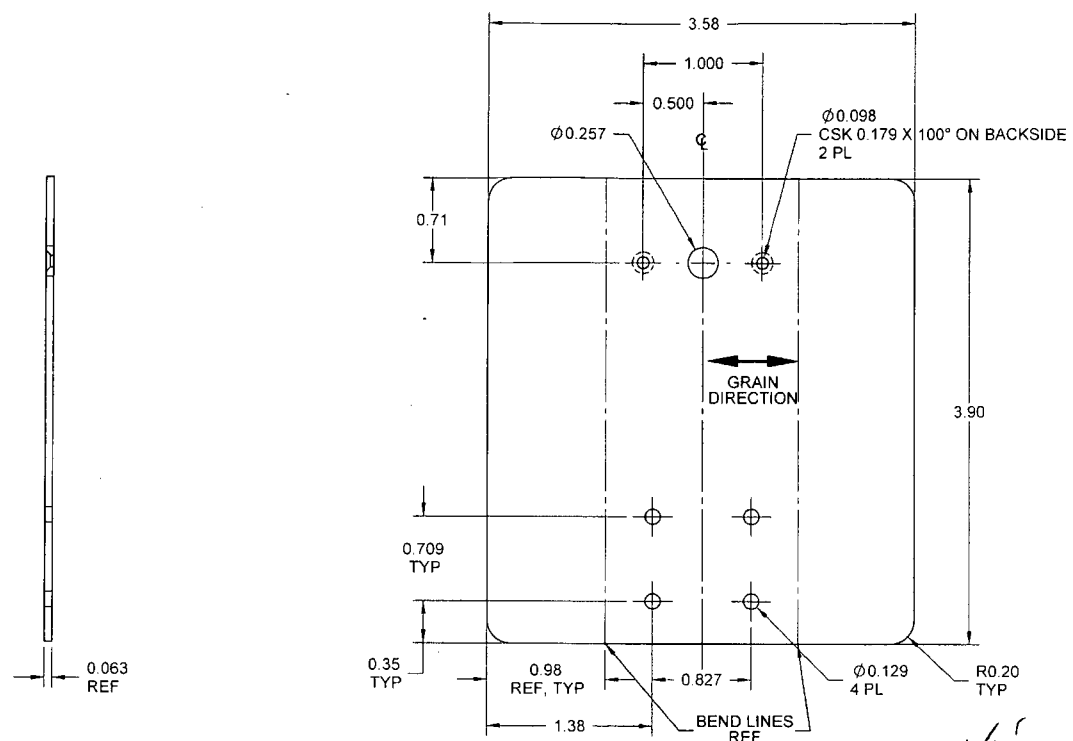
NOTES:

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4006	SHEET 4 OF 6
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D4006-3F FLAT PATTERN

NOTES:

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PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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